

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006772**Date Inspected:** 13-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1845**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 645**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	You Qi Guo and Liu Wei Wei			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>

**Bridge No:** 34-0006**Component:** Tower and OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Joe Alaniz was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA inspector performed limited VT of the 5BE OBG member previously tested and accepted by ZPMC Quality Control personnel. Several of nonconforming discontinuities (arc strikes and 1 crack) were present at various location of noted member. QA Inspector Larry Viars had issued an incident report for the noted discontinuities for today's work shift.

Due to limited time in blast shop, VT was not completed on this work shift.

Bay 11

SMAW welding of weld joint 69 located on WSD1-TL6C/C.

Welder is identified as Mr. Wei Hengbin (068924). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-3312-Tc-P4.

SMAW welding of weld joint 73 located on WSD1-TL6E/L.

Welder is identified as Mr. Liang Yanhai (066457). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-3312-Tc-P4.

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

---

SMAW welding of weld joint 62 located on WSD1-TL6H/L.

Welder is identified as Mr. Liu Qingyong (066479). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-3312-Tc-P4.

SMAW welding of weld joint 17 located on WSD1-FASA3-2C/E.

Welder is identified as Mr. Yu Qinqiang (203787). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-4312-Tc-P4-1.

SMAW welding of weld joint 17 located on WSD1-FASA3-2C/E.

Welder is identified as Mr. Chen Kang (206195). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-4312-Tc-P4-1.

FCAW welding of weld joint 2B located on ESD1-TL7B/L.

Welder is identified as Mr. Li Zhaoqian (048810). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U5-F.

FCAW welding of weld joint 2B located on ESD1-TL7B/L.

Welder is identified as Mr. Li Haidong (047701). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2232-Tc-U5-F.

FCAW welding of weld joint 97 located on ESD1-TL7C/L.

Welder is identified as Mr. Wang Bing (040713). ZPMC QC is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-4132.

Bay 3

SMAW welding of weld joints 131, 132, 005 and 006 located on SSD11-PP081.

Welder is identified as Mr. Sun Guofu (044804). ZPMC QC is identified as Mr. Liu Wei Wei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2233-B-U2-F.

Bay 6

SMAW welding of weld joints 057 located on FB205-017.

Welder is identified as Mr. Lei Hanjie (215672). ZPMC QC is identified as Mr. Liu Wei Wei.

The welding variables recorded by QC appeared to comply with WPS-B-P-2112.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents. QA Inspector issued an incident report on this date for the welding observed.

---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (134-8257-0045), who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Alaniz,Joe	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

---